

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-008493**Date Inspected:** 05-Aug-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Wu Zhi Cheng**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segments**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dan Hernandez was present during the times noted above to observe the fit up, welding and related activities associated with the fabrication of the San Francisco Oakland Bay Self Anchored Suspension Bridge at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

OBG Trial Assembly Yard

Segment 5CW

This QA Inspector observed grinding of bevel area after flame cutting along bottom plate, side plate and deck plate at the 5CW to 5BW splice location.

Segment 2AW

This QA Inspector observed grinding of weld profile on a Complete Joint Penetration (CJP) weld joint along the exterior of the side plate to bottom plate splice, counter weight side.

Segment 4BW

This QA Inspector observed grinding of MT reject on fillet weld at the floor beam diaphragm to floor beam connection at panel point 26.

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## WELDING INSPECTION REPORT

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### Segment 3AW

This QA Inspector observed Shielded Metal Arc Welding (SMAW) in progress of a fillet weld joint. The Weld joint is designated as SSD9-PP019-003. The welder is identified as #048659 and was observed welding in the 2F (horizontal) position using approved Welding Procedure Specification WPS-345-SMAW-2G (2F)-FCM-repair-1.

### Segment 2AE

This QA Inspector observed bolt tension verification using the turn of nut method on M22x65 bolts at panel point 16 on the inside angle of the lower chevron brace.

### Segment 2AE

This QA Inspector observed bolt tension verification using the turn of nut method on M22x65 bolts at panel point 17, 18 on the inside angle of the lower chevron brace.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

#### Summary of Conversations:

No relevant conversations.

#### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372 , who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hernandez,Dan	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon,Albert	QA Reviewer

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